

IN THE SUBSTITUTE SPECIFICATION:

Page 9, amend the paragraph starting at line 5 and ending at line 11 as follows:

[0026] Depending on the workpiece flexibility, one or more gripper storage units 14 for different gripping tools 11, 12, 13 may be arranged at the turning station 5 in the working area 10 of the transport robots 8, 9. Three gripper storage units 14 ~~are~~ may be arranged in a row or in an arc for each transport robot 8, 9 as shown in Figures 1 and 2. The gripper storage units 14 are intended for particular models and model variants and may be provided with suitable conveyors for introducing and removing the gripping tools 11, 12, 13. The gripping tools can thus be replaced or removed and introduced for measuring and maintenance work or for other purposes.

Page 10, amend the paragraph starting at line 13 and ending at line 22 as follows:

[0030] As an alternative to the manual feed of the workpieces 2 by a worker, the workpieces 2 may also be transferred at the work station 6 to the gripping tools 11, 12, 13 mechanically and automatically. Such a design is shown, for example, in Figure 2 at the second turning station 5 and the work station 6 located there. A robot 20, which has primarily conveying and handling tasks and transfers the workpiece to the waiting transport robots 8, 9 of the second turning station 5 after the completion of the machining of the workpiece in the machining station 15, ~~is arranged in the upstream machining station 15. This transfer preferably follows directly in~~ the so-called handshake operation. The gripping tools of the robots 8, 9, 20 are designed correspondingly for this purpose. As an alternative, the transfer may also take place by means

of an ~~intercalated~~ interposed workpiece storage unit on a table not shown.

Page 13, amend the paragraph starting at line 11 and ending at line 22 as follows:

[0039] In the second turning station 5 according to Figure 2, a plurality of gripper storage units 14 for corresponding model-related and optionally also variant-related gripping tools 11, 12, 13 are again located at the edge of the working area of the transport robots 8, 9. These [gripping tools] may differ from the set of grippers of the first turning station 5 and are therefore identified by the designations A', B' and C' as well as A3, B3 and C3. As is illustrated in Figure 2, the transport robots 8, 9 also hold different gripping tools A/A1 and A'/A3 in the two turning stations 5. Joining operations are again performed by the two welding robots 18 of the second machining station 16 at the work station 7 of the second turning station 5, and, for example, the components prepared for the operation in the preceding station are joined, e.g., tacked and/or fully welded. An additional transport robot 20, which takes over the workpiece 2 after the completion of the joining operation and transports same to the workpiece discharge unit 4, is likewise arranged in the second machining station 16.